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Fig. 1

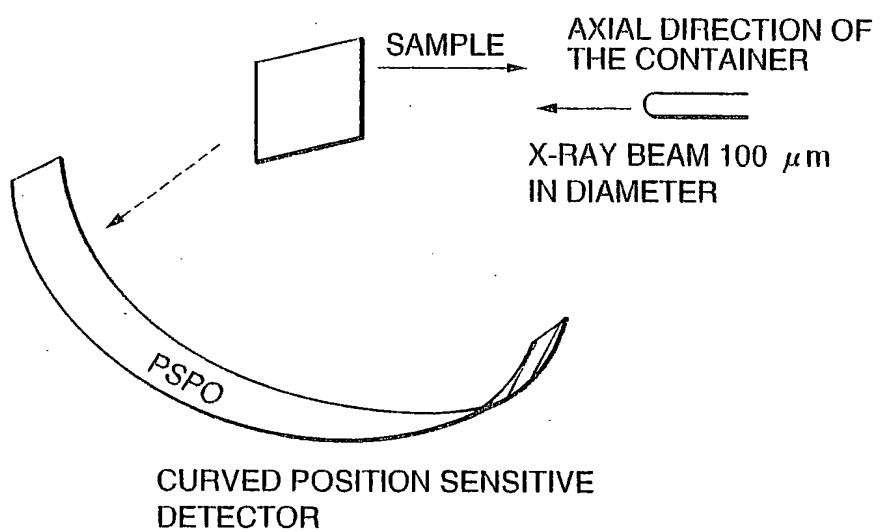


Fig. 2

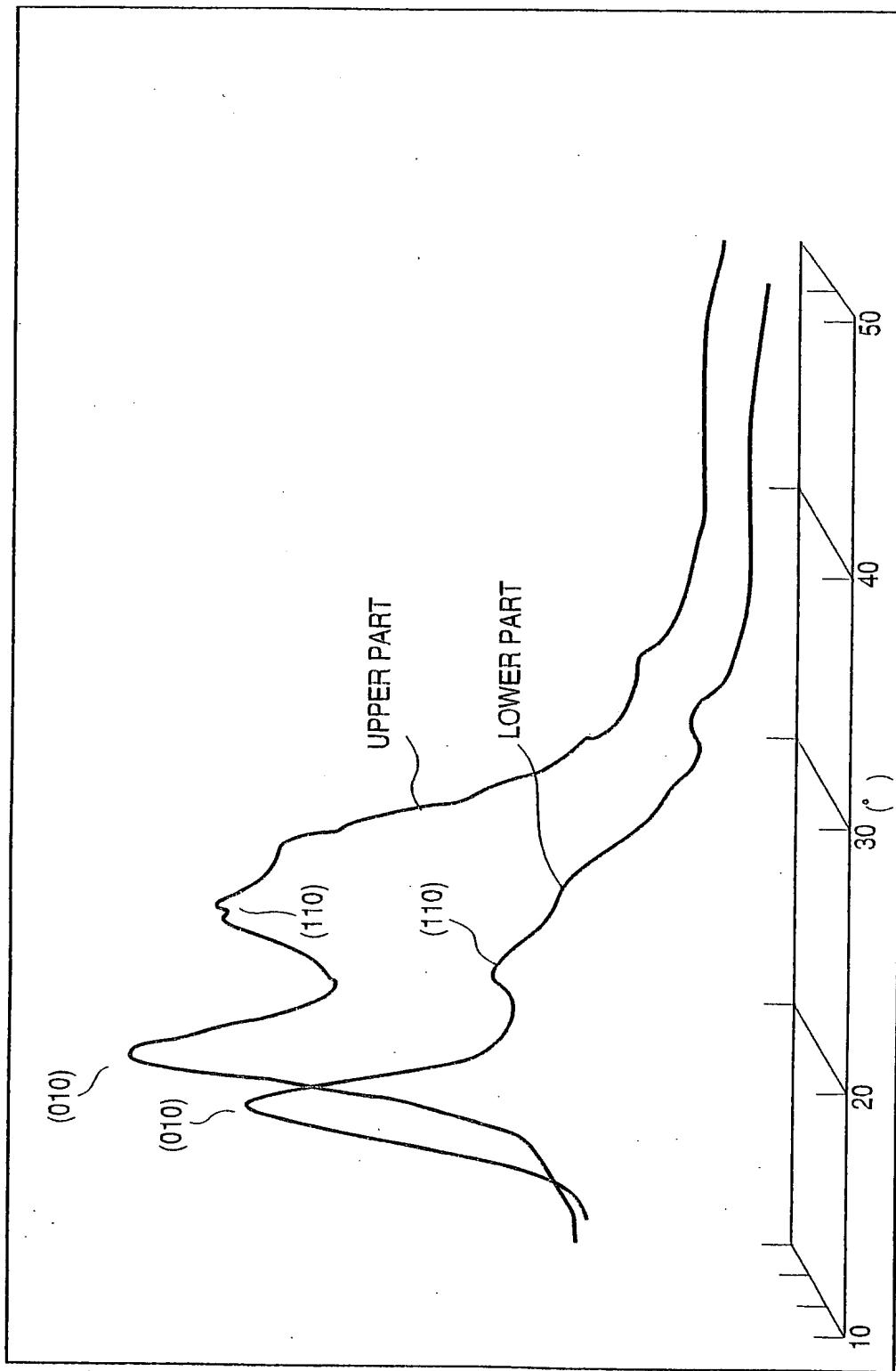
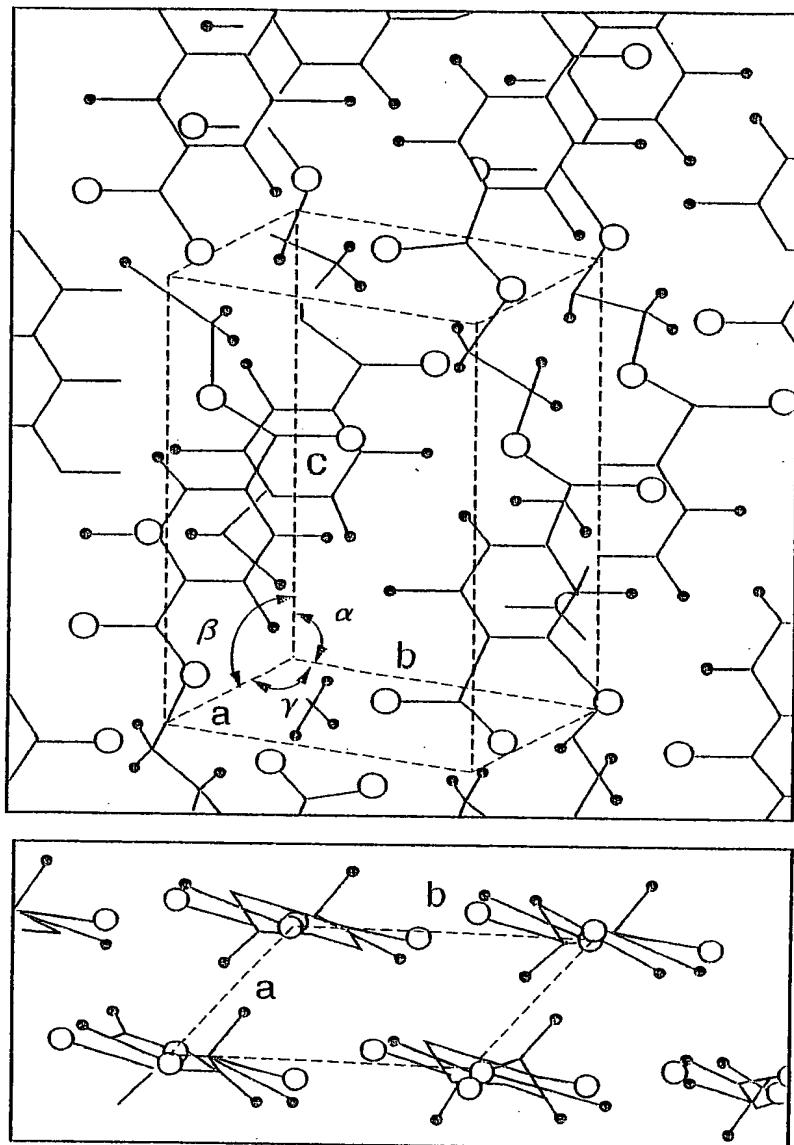


Fig. 3



4 / 30

Fig. 4

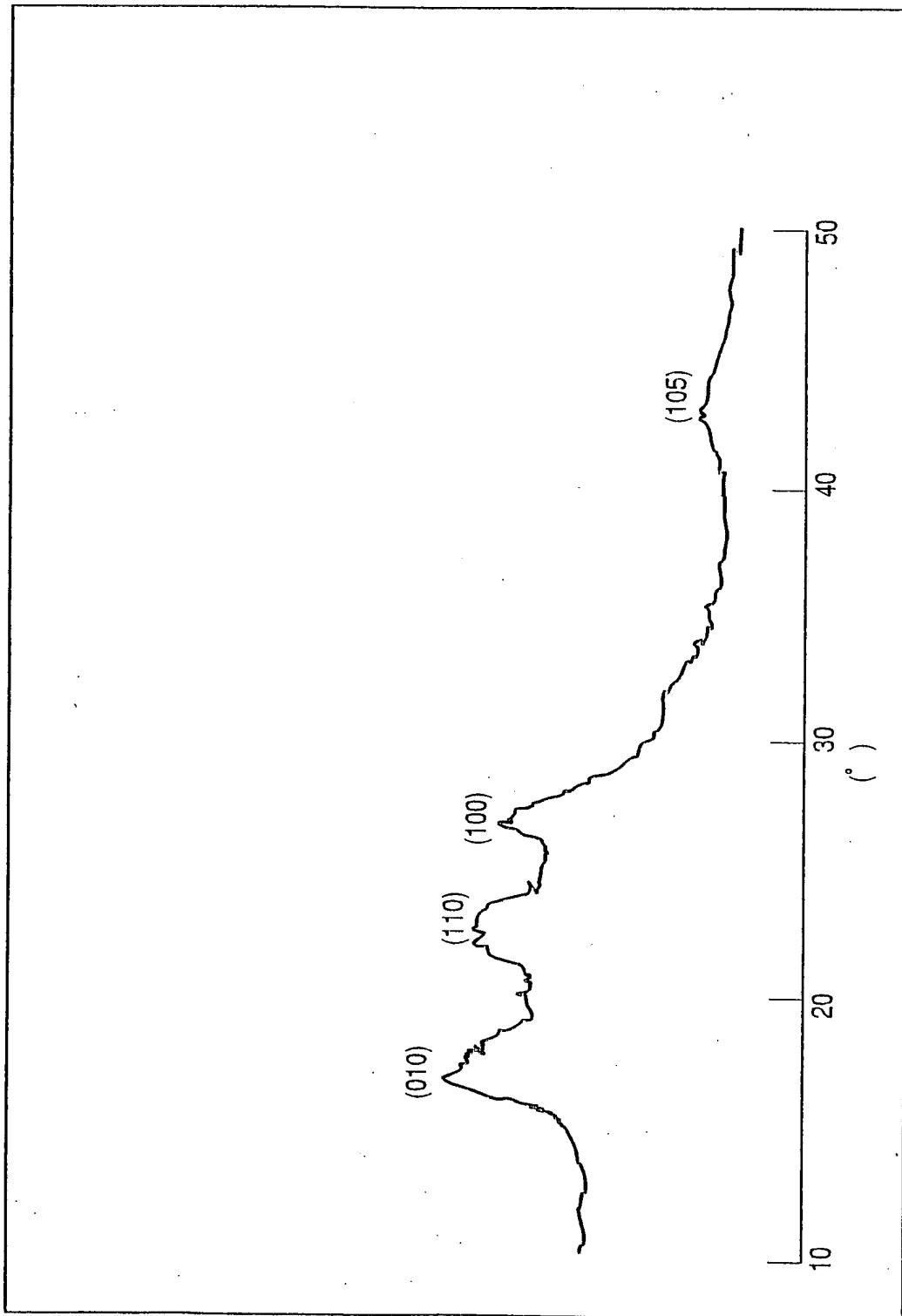


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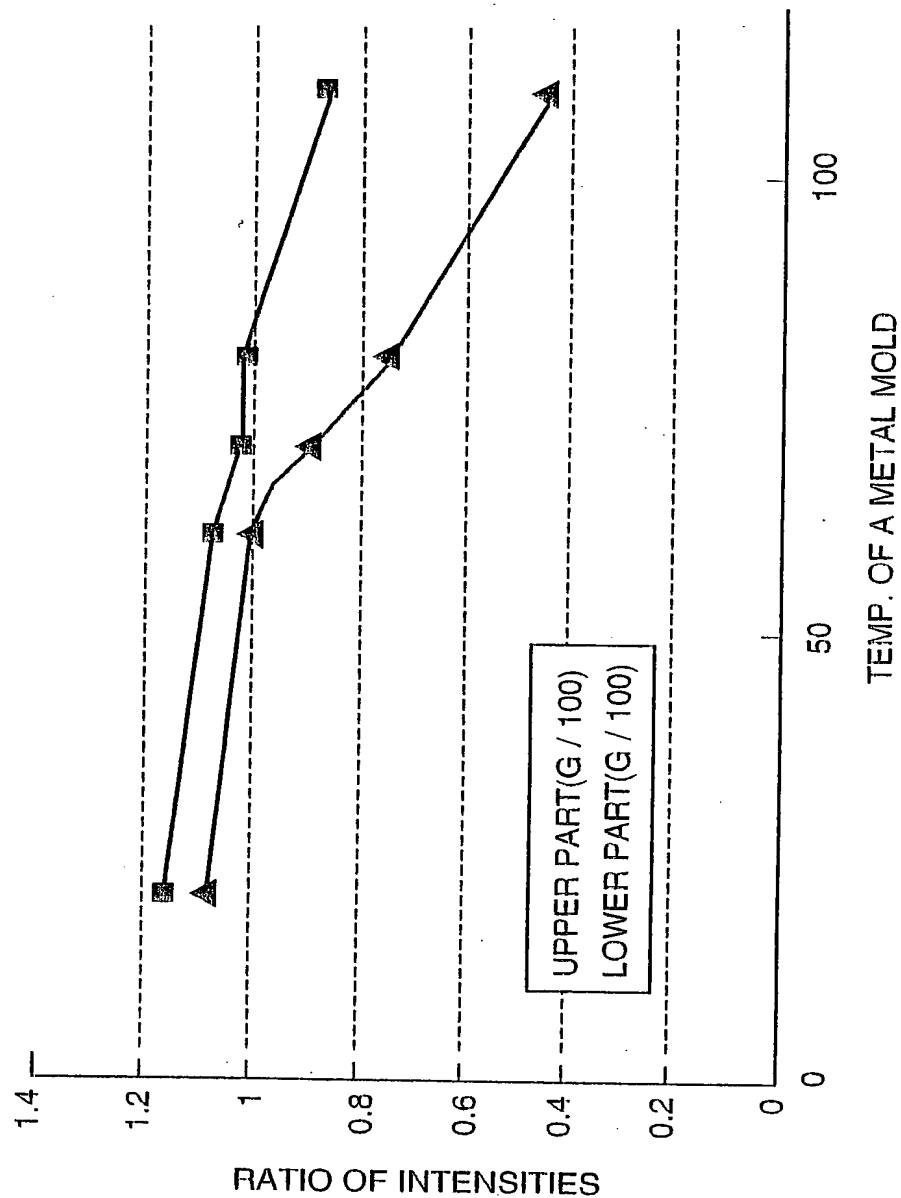


Fig. 6

METHOD OF STRETCHING USING A FLANGE  
 AND THE SHAPE OF A PLUG

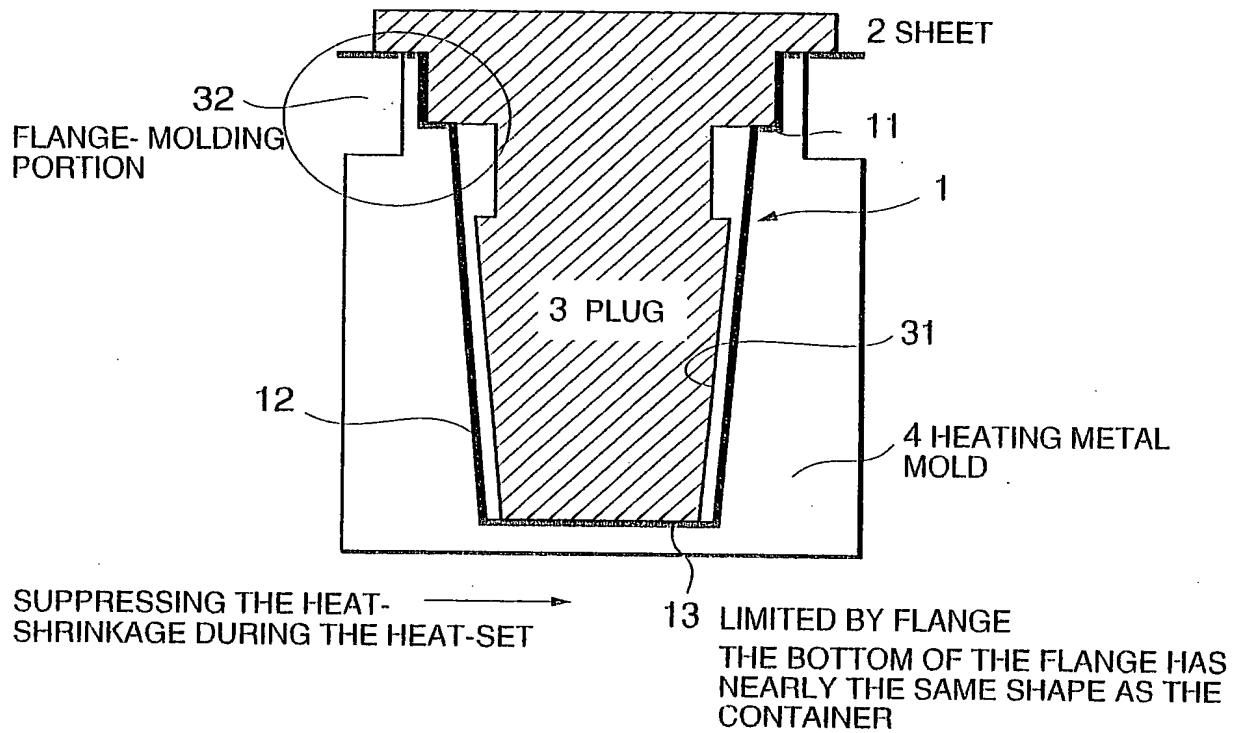
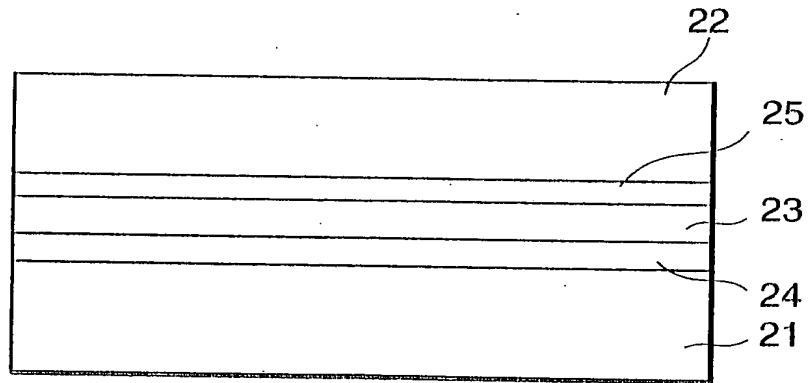
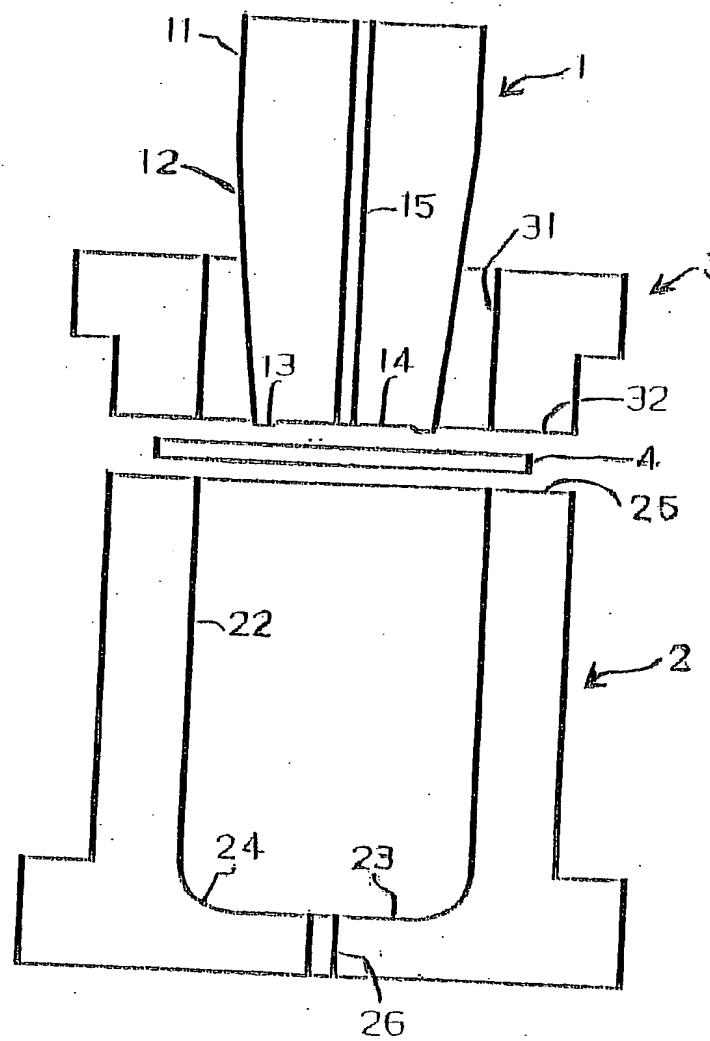


Fig. 7



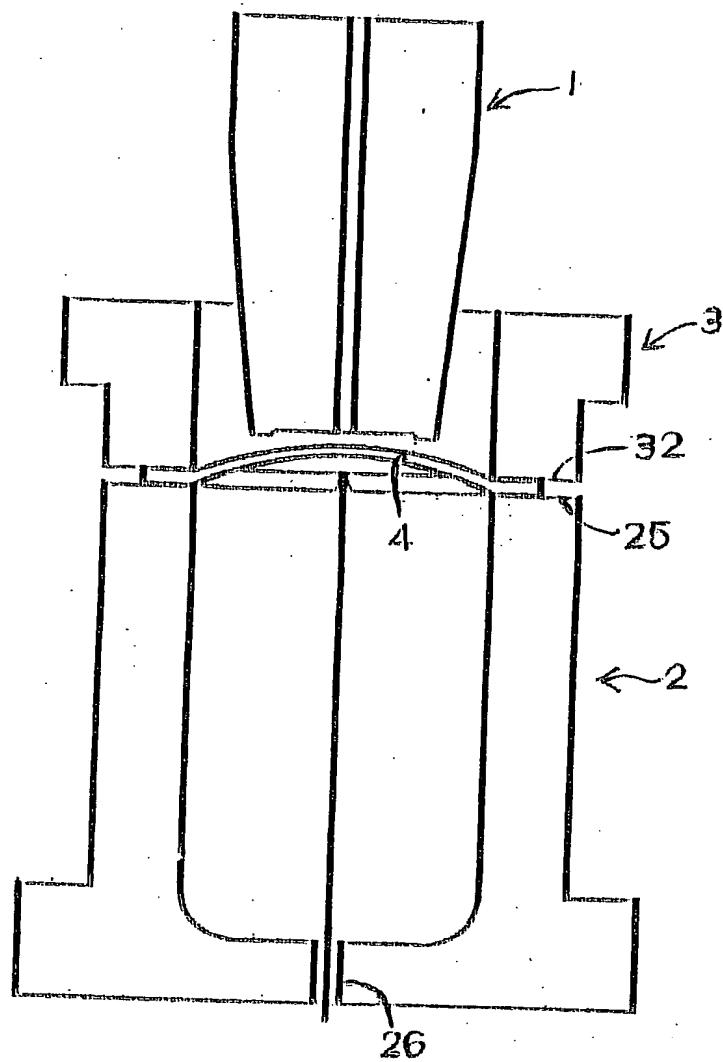
7 / 30

Fig. 8



8 / 30

Fig. 9



9 / 30

Fig. 10

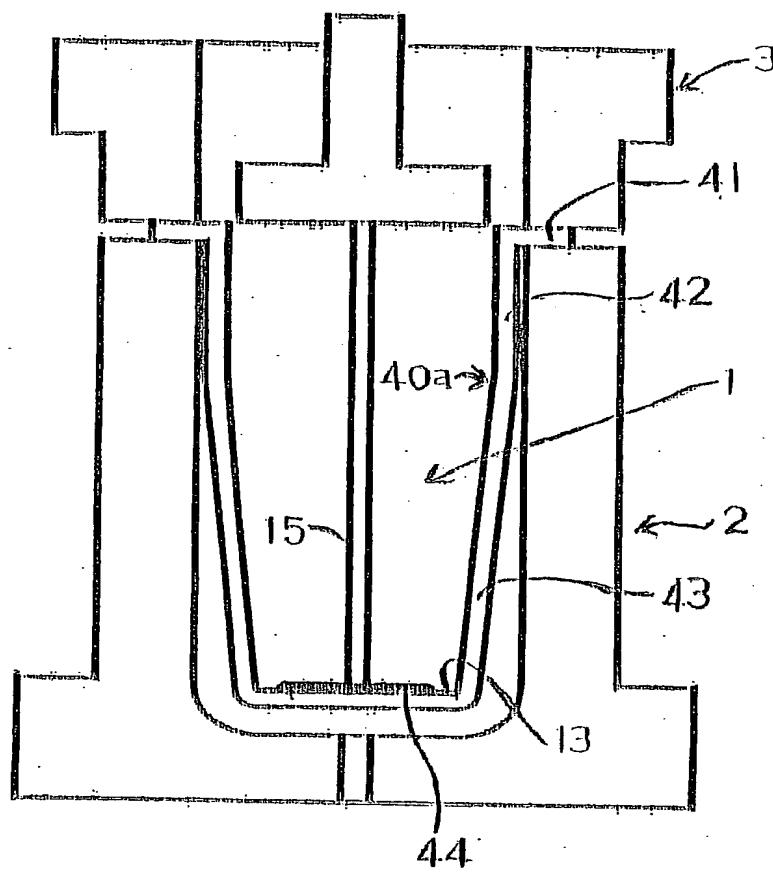


Fig. 11

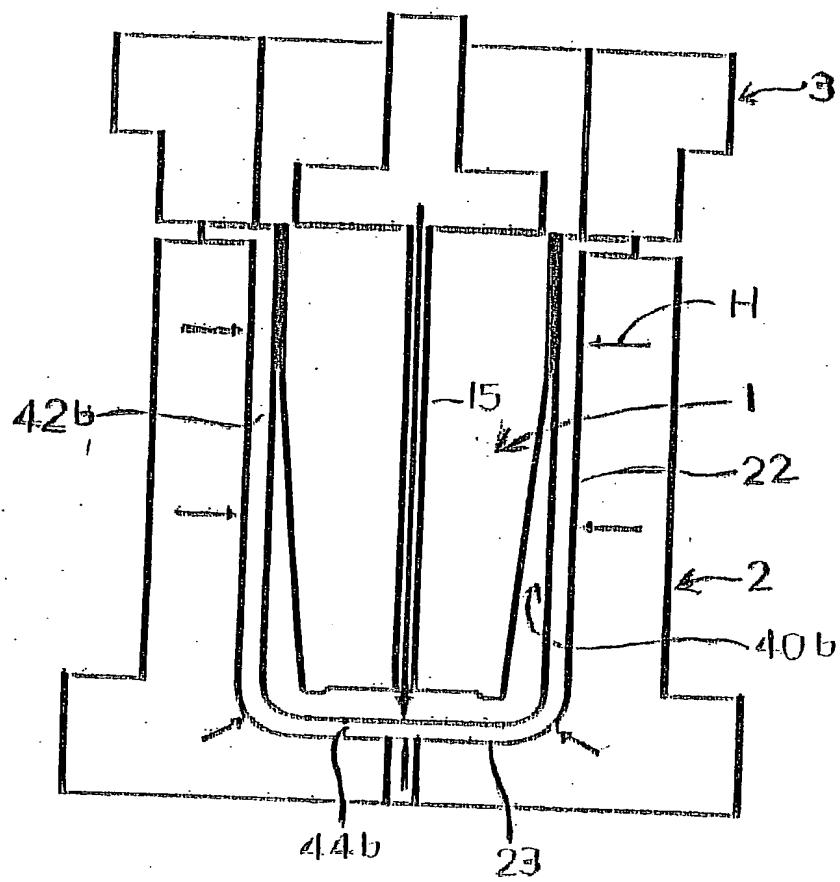


Fig. 1 2

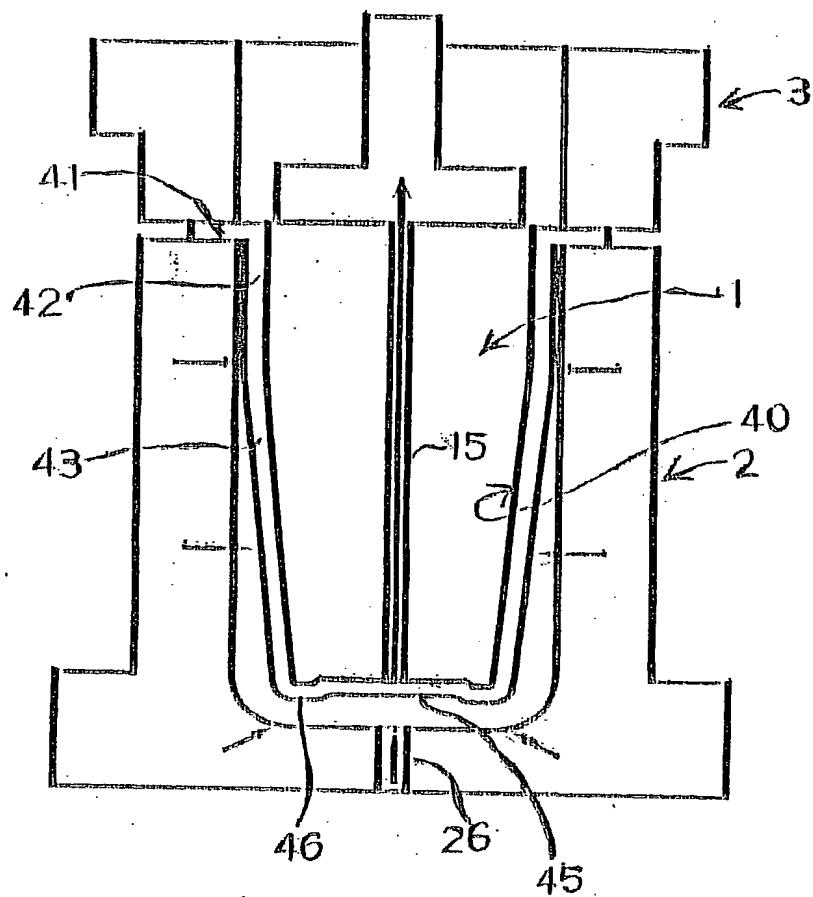


Fig. 13

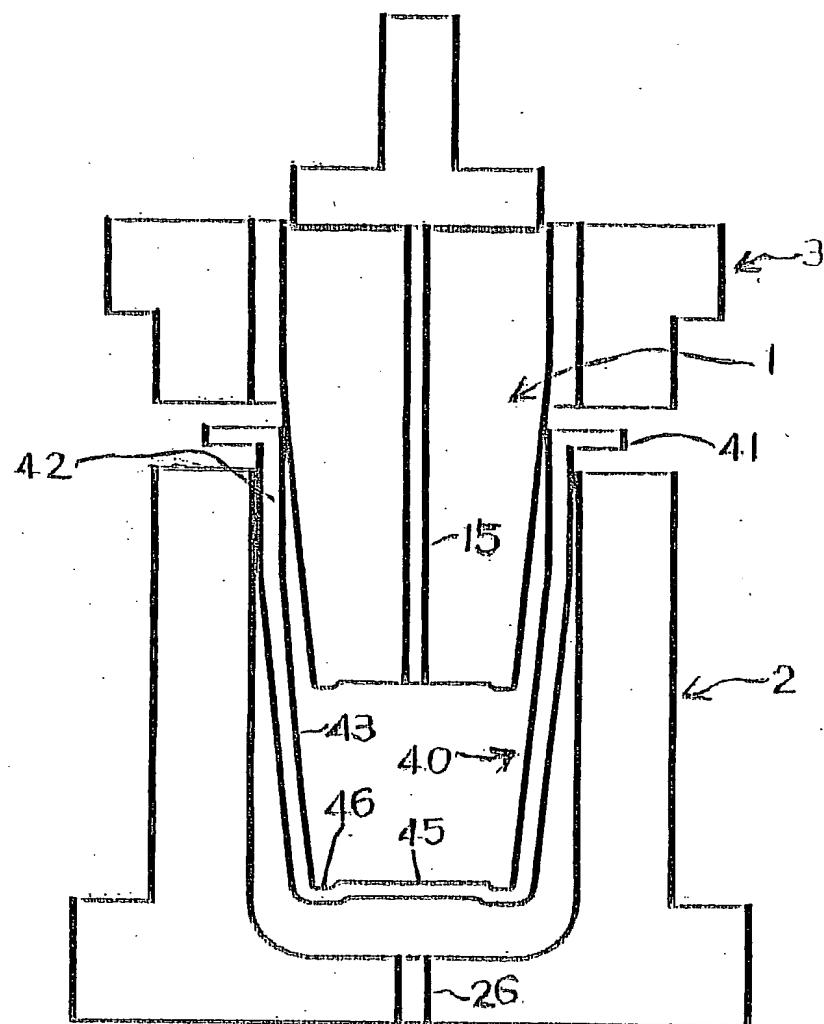
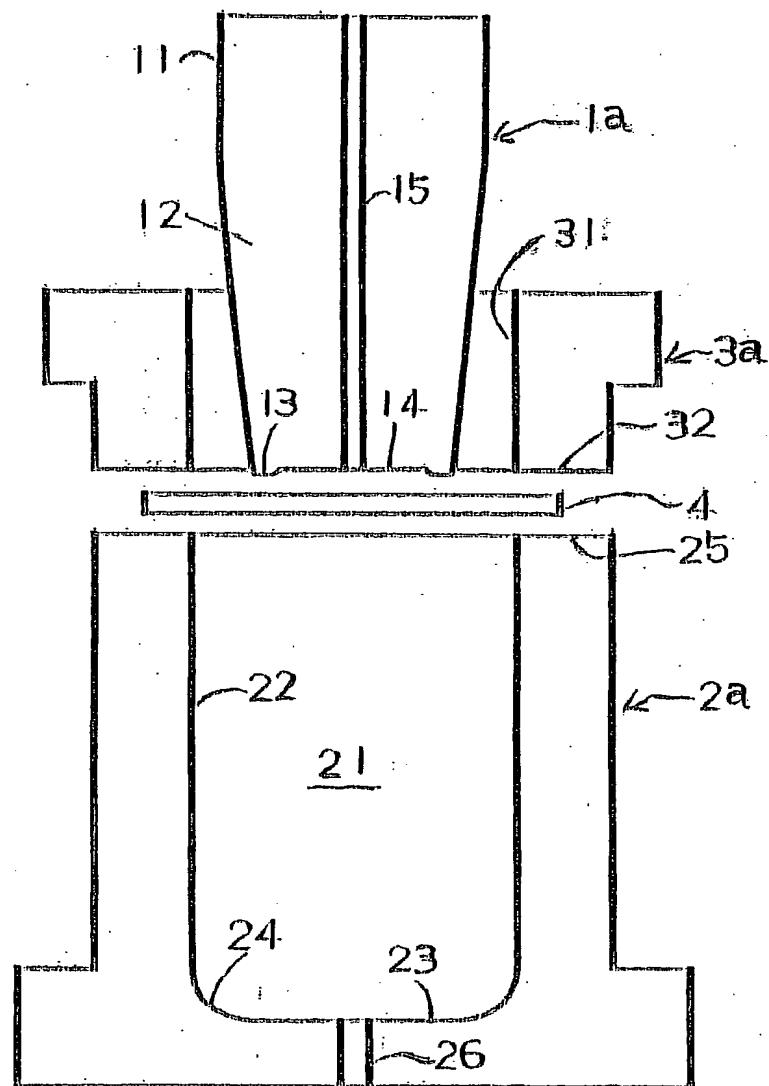
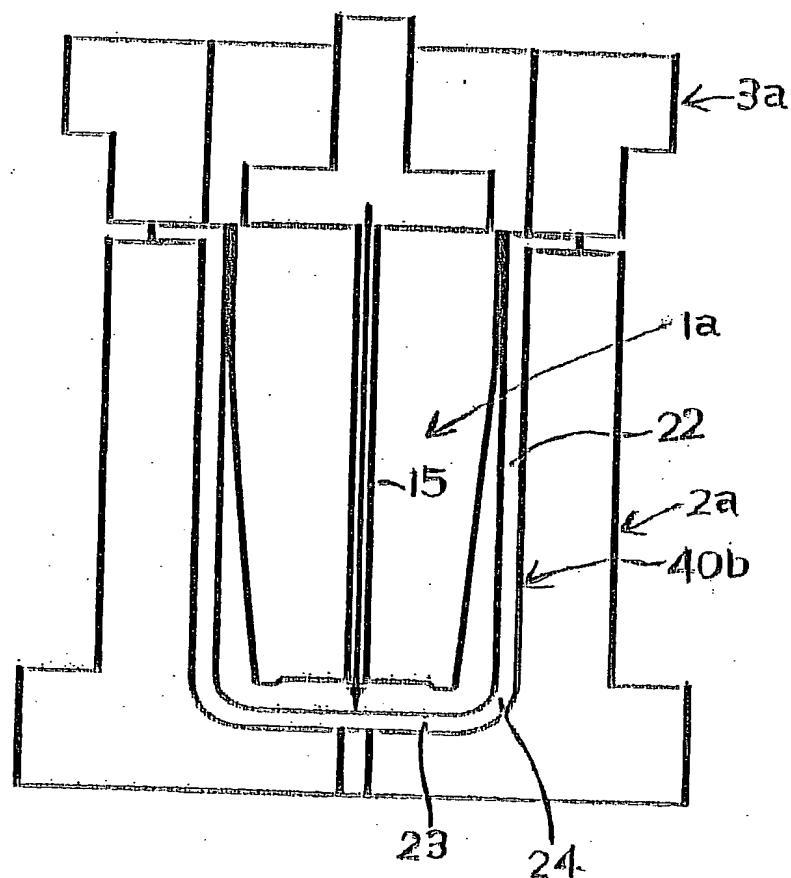


Fig. 14



1 4 / 3 0

Fig. 15



15/30

Fig. 16

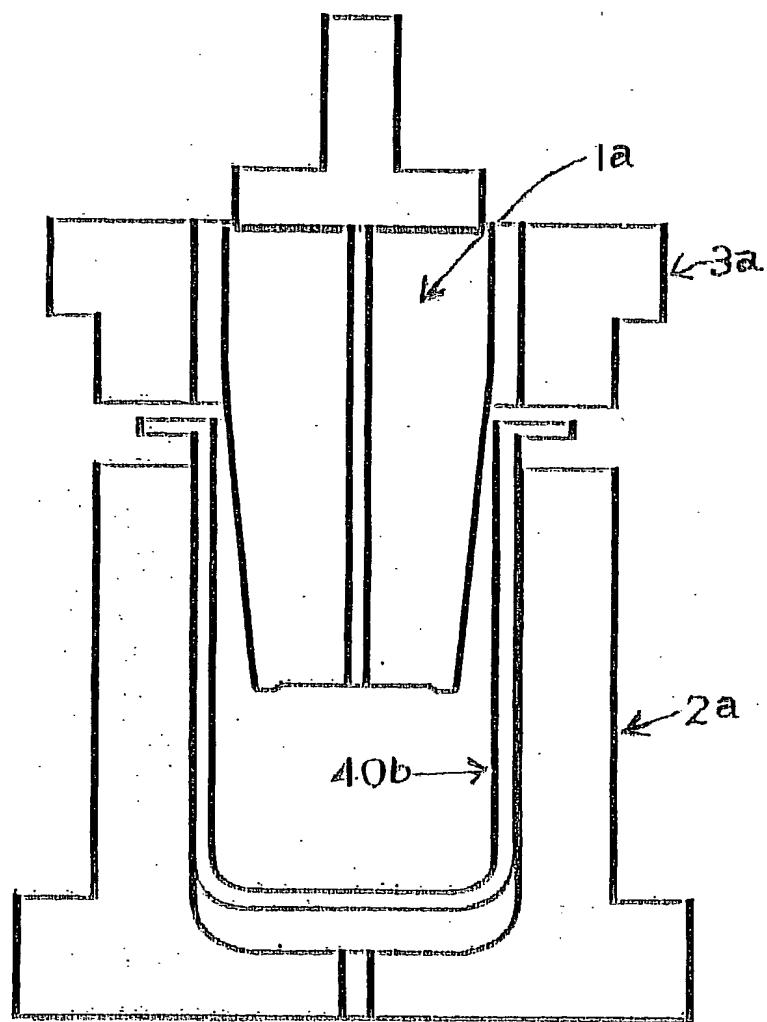


Fig. 17

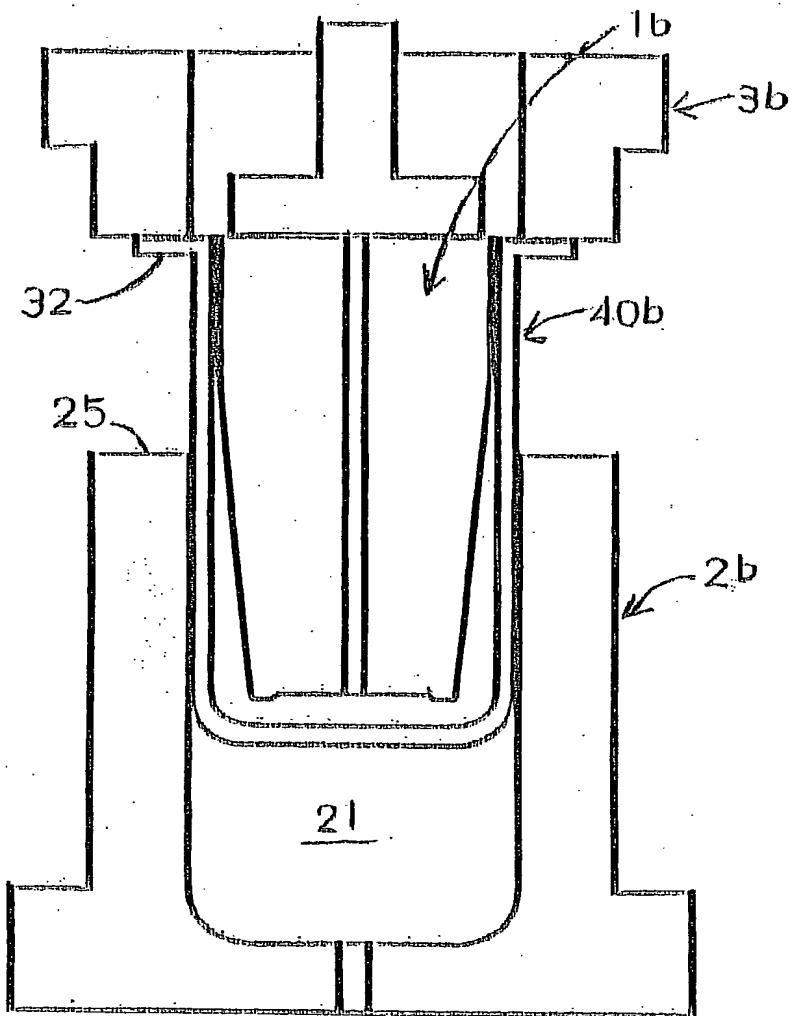


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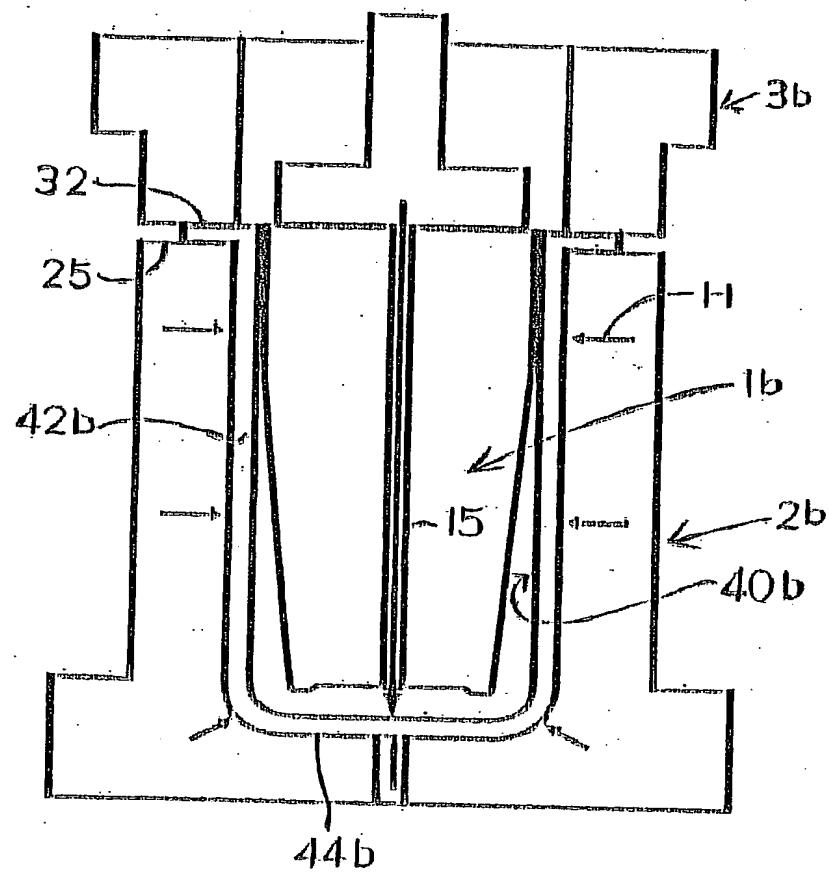


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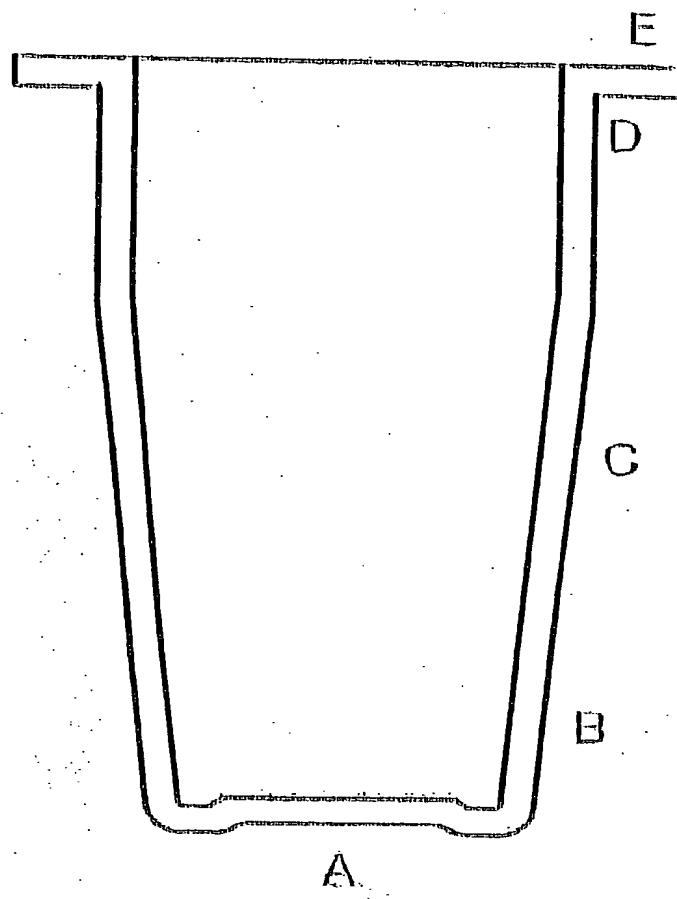


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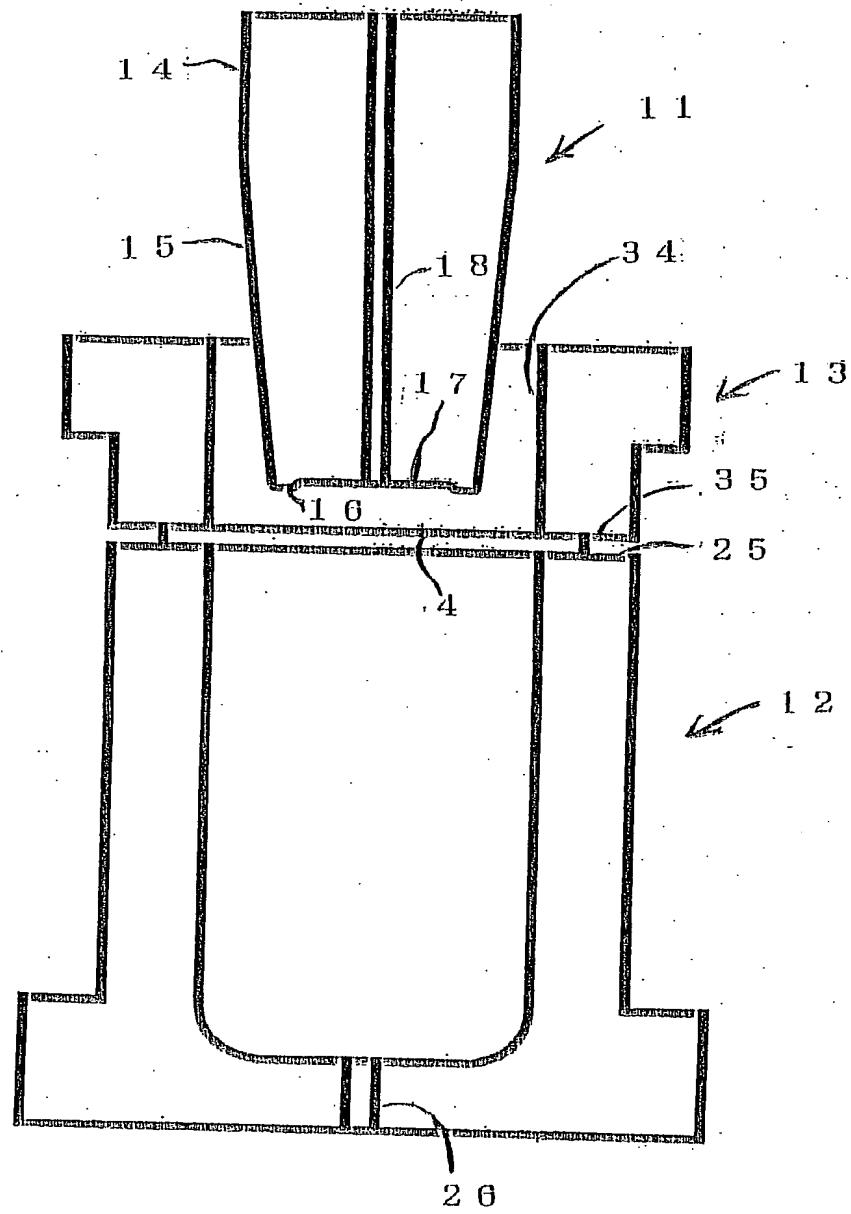
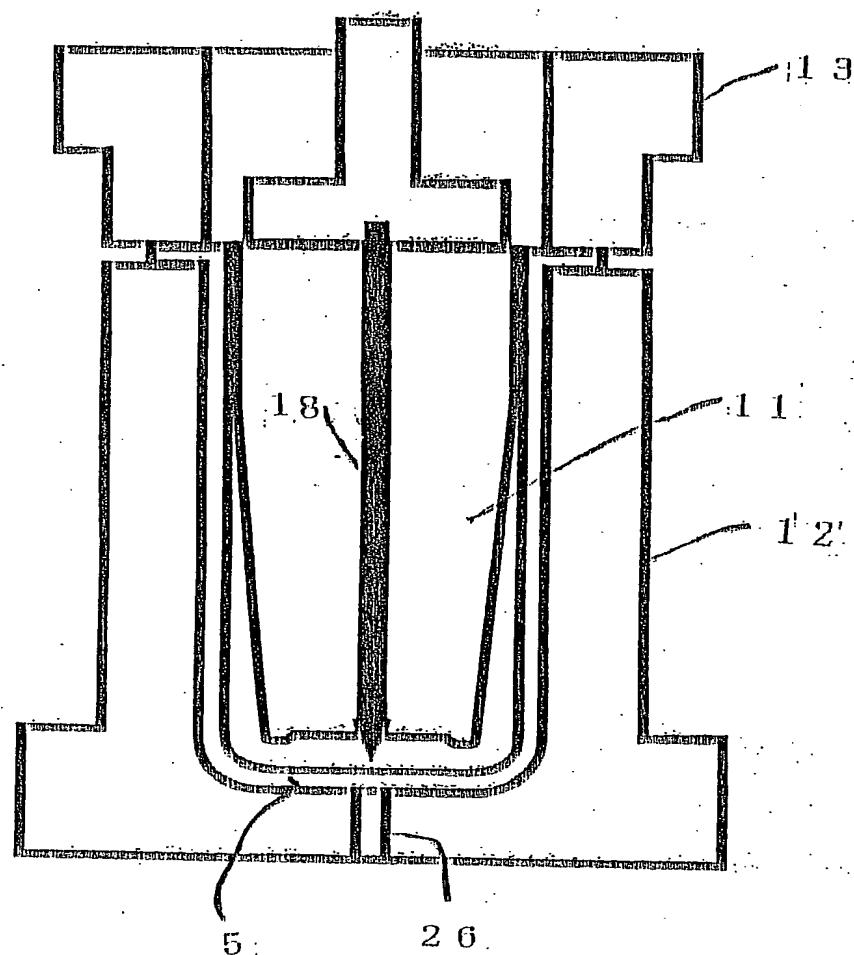
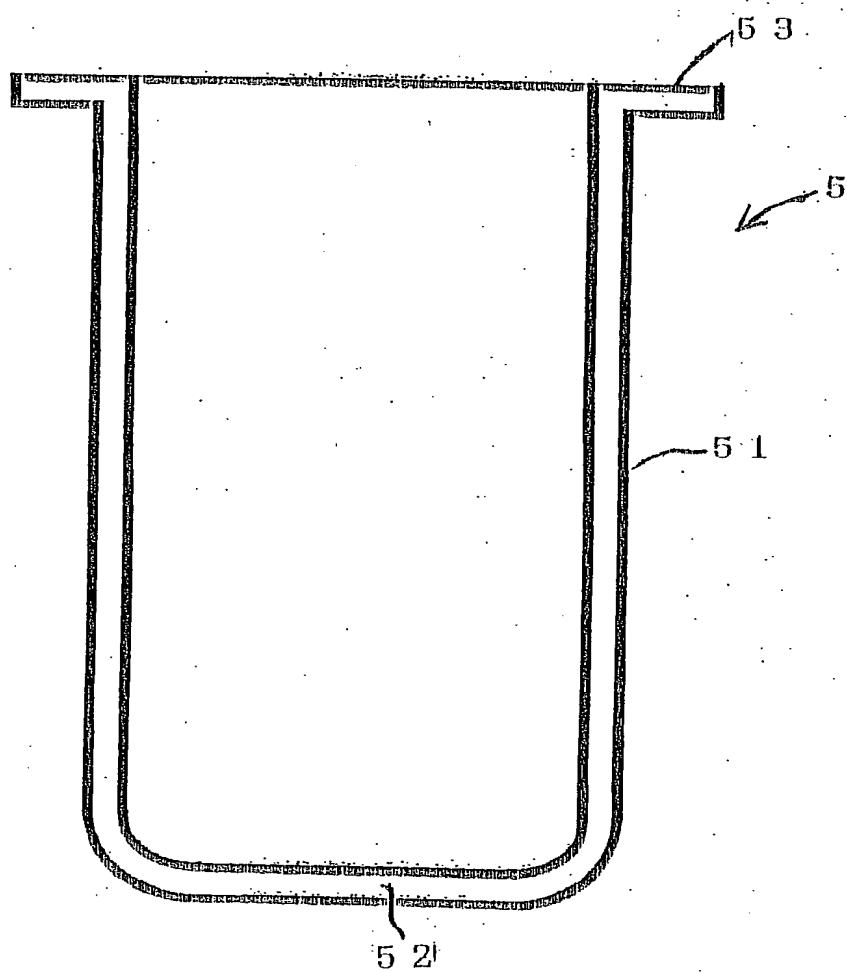


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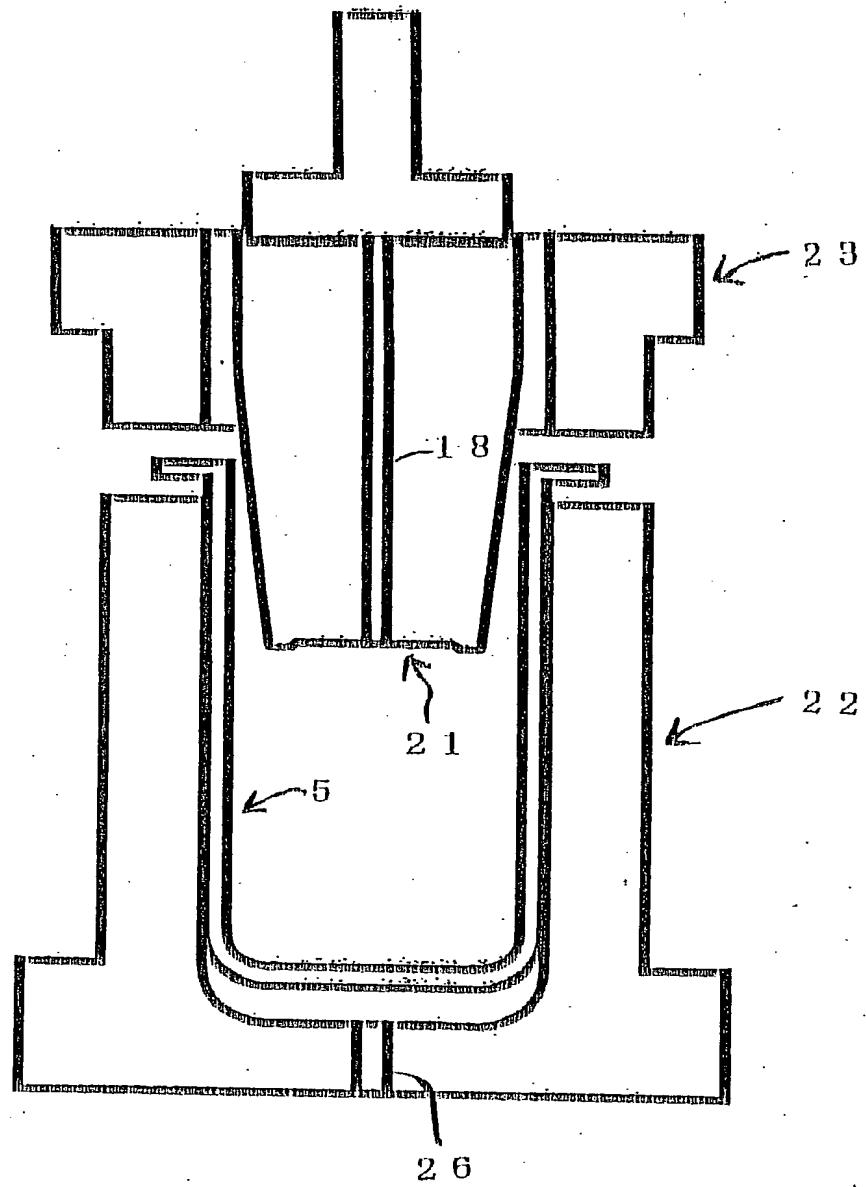
21 / 30

Fig. 22



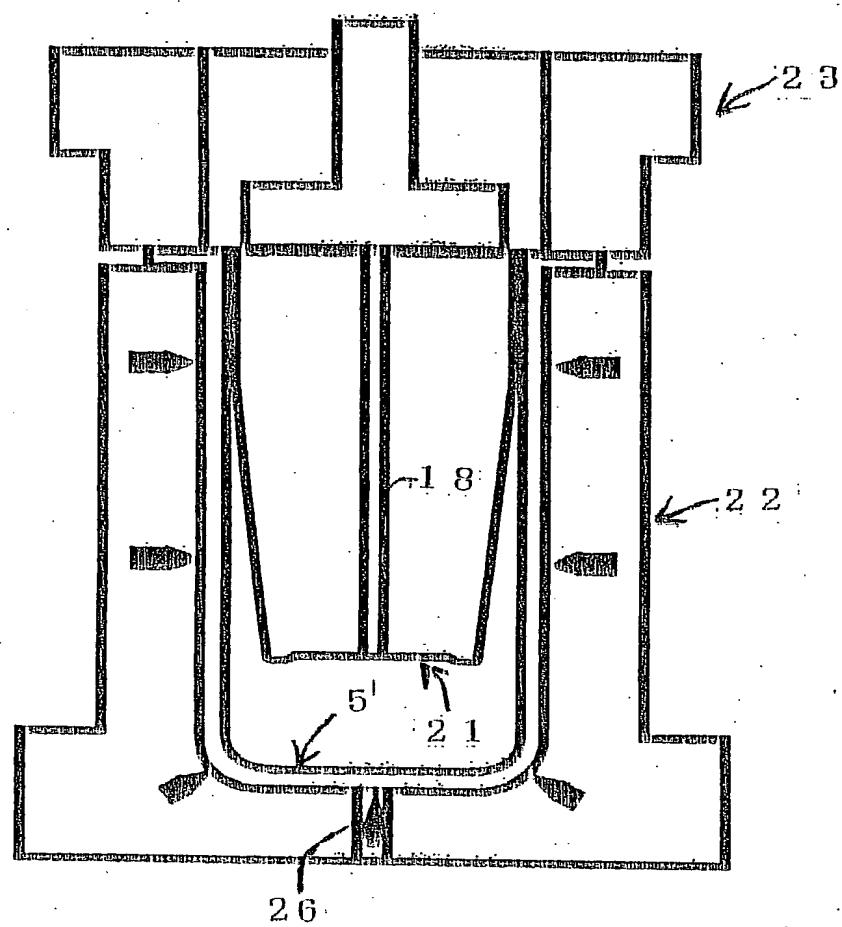
22/30

Fig. 23



23/30

Fig. 24



24/30

Fig. 25

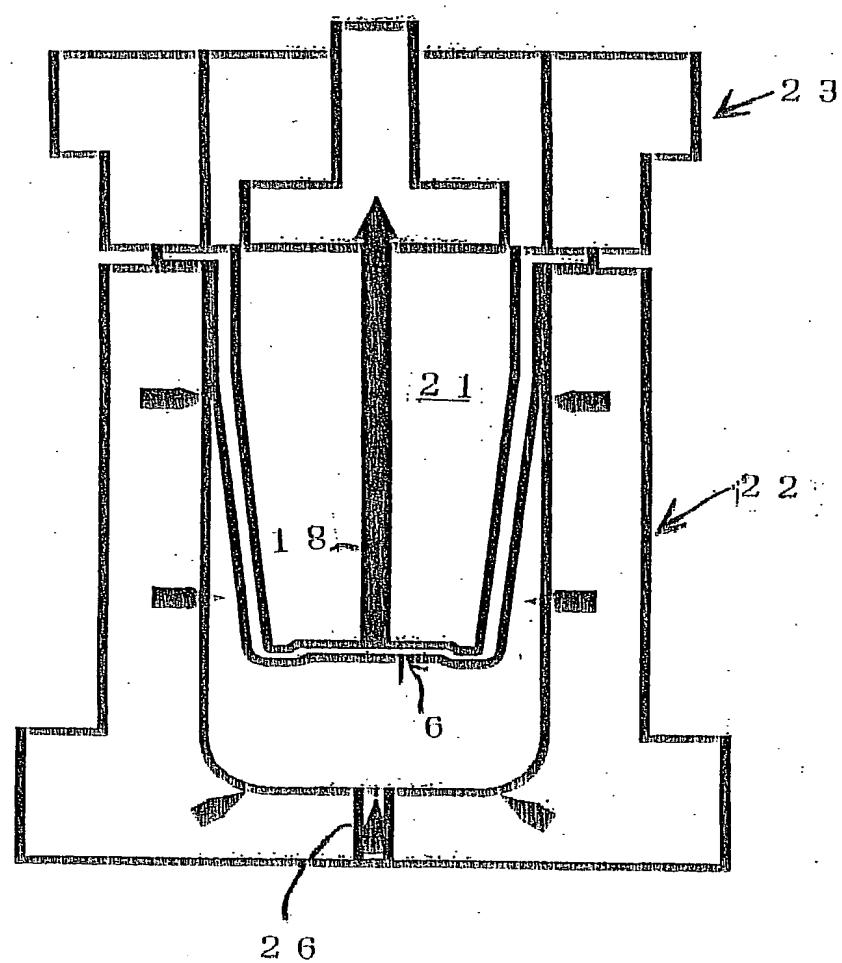
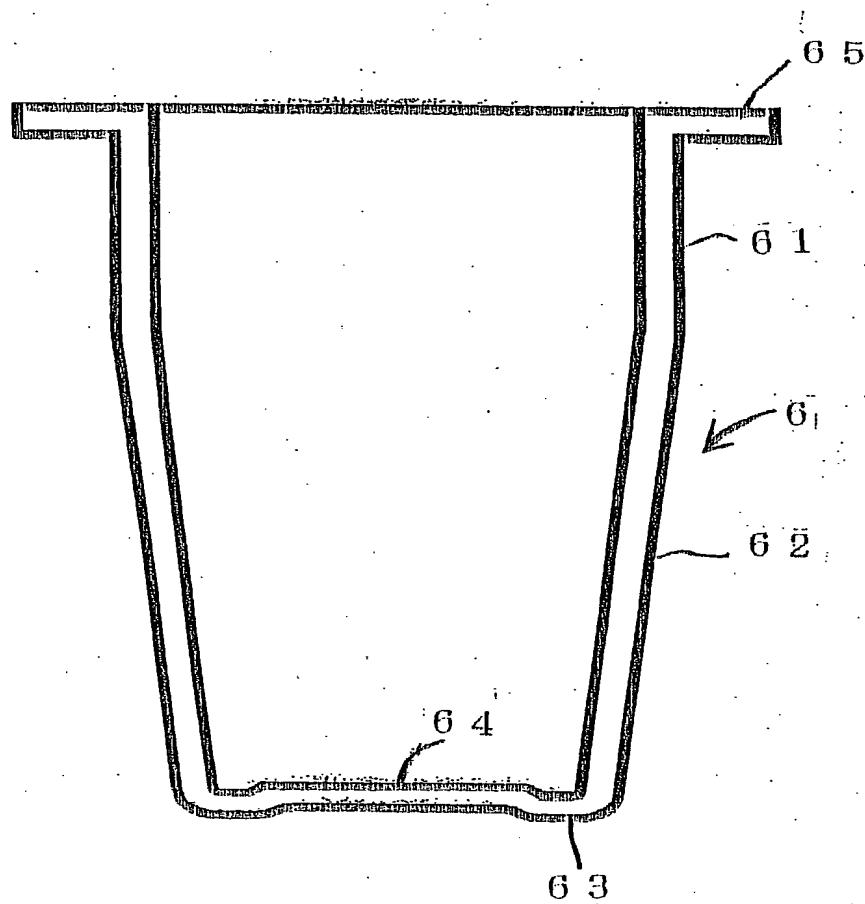
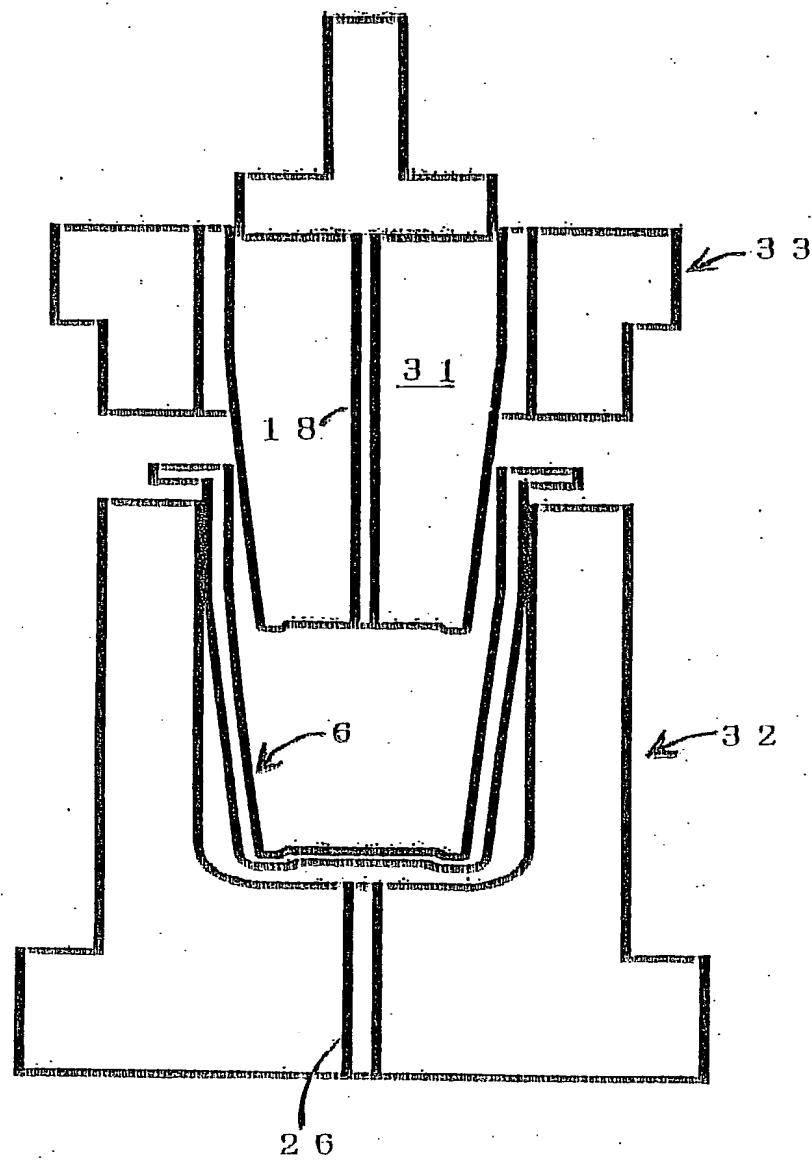


Fig. 26



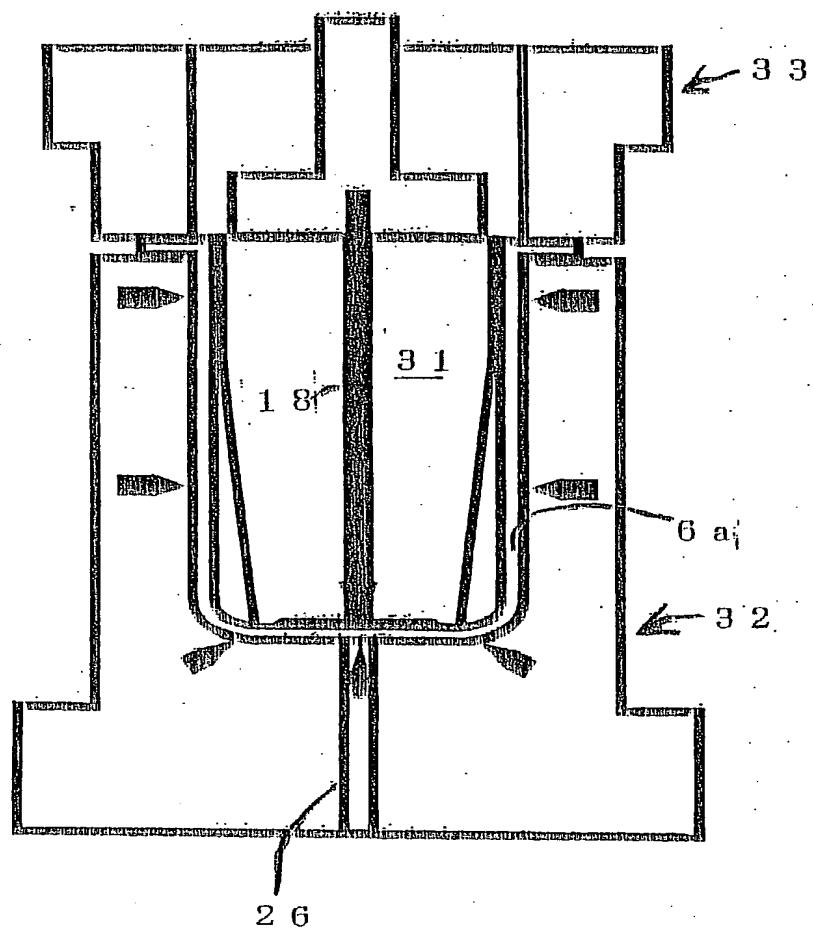
26/30

Fig. 27



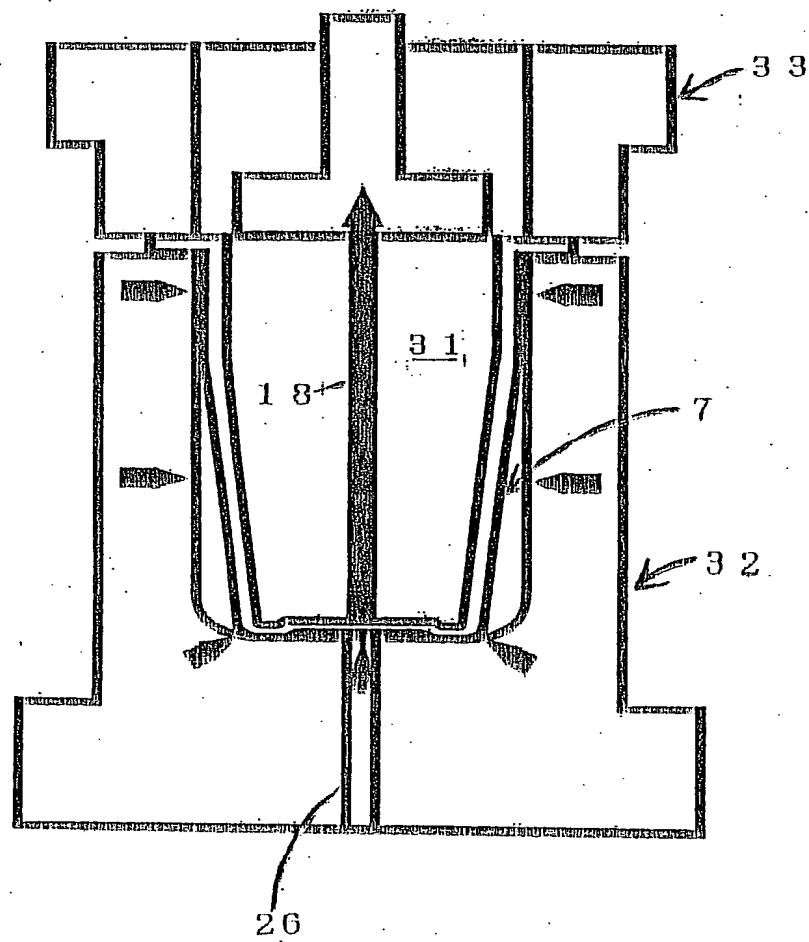
27 / 30

Fig. 28



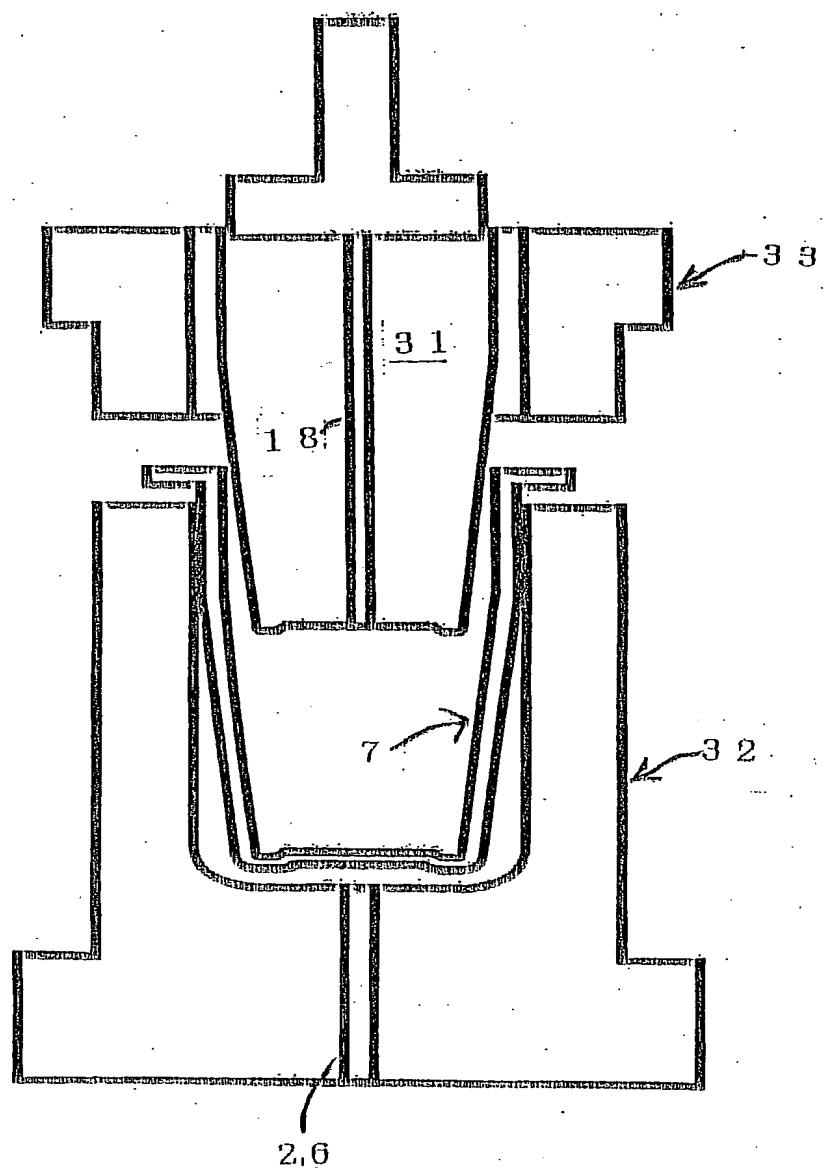
28 / 30

Fig. 29



2 9 / 3 0

Fig. 30



30 / 30

Fig. 31

